

Work Order ID 53957

November 23, 2009 3:34:43 PM



Page 1

Item ID:	D3957-2	Accept		Setup	Start	
Revision ID:	A				Stop	
Item Name:	Hinge, Door RH Upper					
Start Date:	23/11/2009	Start Qty:	8.00	Cust Item ID:		
Required Date:	02/12/2009	Req'd Qty:	8.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>RL</u>	Date:	<u>09/11/23</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3957	A

100		0.00				8	0		
-----	--	------	--	--	--	---	---	--	--

	Bandsaw	Memo	cut blank to 3.200" long	0.00					
Jeaspa Bandsaw									

110		0.00				8	1		
-----	--	------	--	--	--	---	---	--	--

	HAAS 1	Memo	1-Machine as per Folio FA838	0.00					
HAAS CNC vertical machine #1		FOLIO REV:	<u>A</u>						
		DWG REV:	<u>A</u>						

2-FINISH TAPPING TO FULL DEPTH BY HAND AS PER DWG

3-DEBURR AS PER dWG




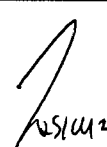
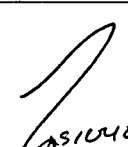

DI 09/11/24

JK 09/11/25

Ro

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		D350-600					

Part No: D3957-2 PAR #: N/A Fault Category: Mach. NCR: Yes No DQA: HA Date: 09.12.08
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: HA Date: 09.12.08

NCR: 53957		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/11/25	110	- one part dimension .250 \pm .010 is .235 at one end only, part		- replace : scrap part.	JK 09/11/25	B.A 09/11/27		
		wasn't sitting correctly on jaws. Part is tapered. + is part acceptable? <u>no</u>						
		RC. lack of effort.						

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

November 23, 2009 3:34:43 PM



Accept

**Setup Start**

Stop

**Cust Item ID:**

Abstract

Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

**Draw
Number**

Draw
Rev.

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/30 *[Signature]*

11/09-11-32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 3:34:53 PM

Page 1

Work Order ID: 53957



Parent Item: D3957-2A-PRELIM



Parent Item Name: Hinge, Door RH Upper

Start Date: 23/11/2009

Required Date: 02/12/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X04.00 0		Purchased	No				f	16.2178	2.2456			



6061-T6 Bar .750 x 4.00

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

16.2178

101283

4.3498

104186

11.868

2,2456 DI 09/11/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 53957
Description: hinge, door fb upper		Part Number: D3957-2
Inspection Dwg: A3957 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

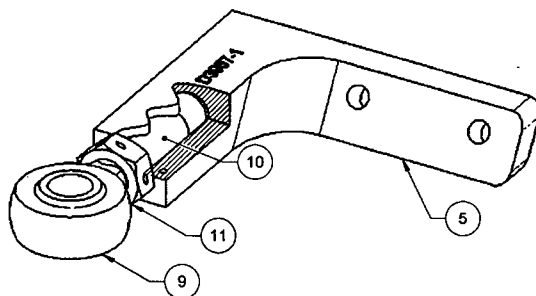
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	$\pm .030$	3.001	✓			
.69	$\pm .030$.687	✓			
.281	$\pm .010$.280	✓			
.281	$\pm .010$.280	✓			
.094	$\pm .010$.094	✓			
.125	$\pm .010$.125	✓			
Ø.063	$\pm .005$.065	✓			
.563	$\pm .010$.563	✓			
1.250	$\pm .030$	1.260	✓			
2.31	$\pm .030$	2.307	✓			
120°	$\pm .5°$	120°	✓			
.250	$\pm .010$.244	✓			
Ø.203	$\pm .006$ $\pm .001$.204	✓			
.39	$\pm .030$.384	✓			
.390	$\pm .030$.386	✓			
1.170	$\pm .010$	1.170	✓			

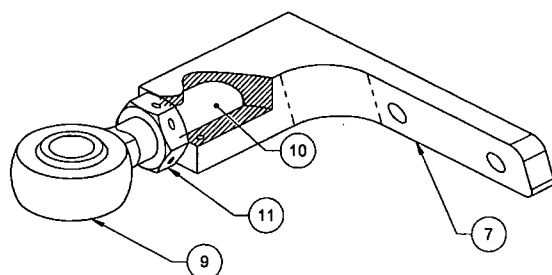
Measured by: JL	Audited by: B.A	Prototype Approval:	N/A
Date: 09/11/25	Date: 09/11/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

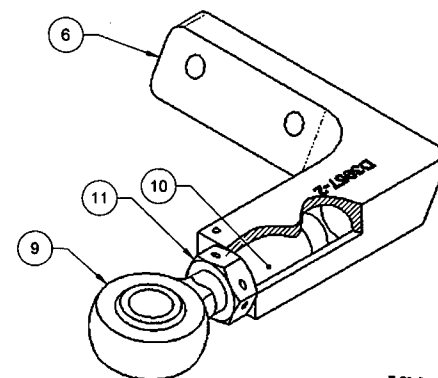
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



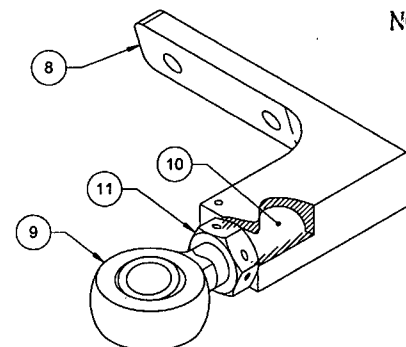
D3957-041 HINGE ASSY, DOOR LH UPPER



D3957-043 HINGE ASSY, DOOR LH LOWER



D3957-042 HINGE ASSY, DOOR RH UPPER



D3957-044 HINGE ASSY, DOOR RH LOWER

SHOWN IN
FIG. 1
UNCONTROLLED COPY
SUBJECT TO CHANGE
WITH NO NOTICE
WORK ORDER NO.
53957
09-11-23

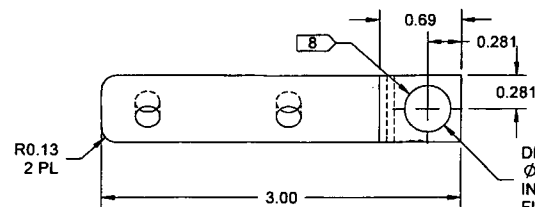
RELEASED
2009-10-08
JWP

A	NEW ISSUE	09.09.03
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.09.03	

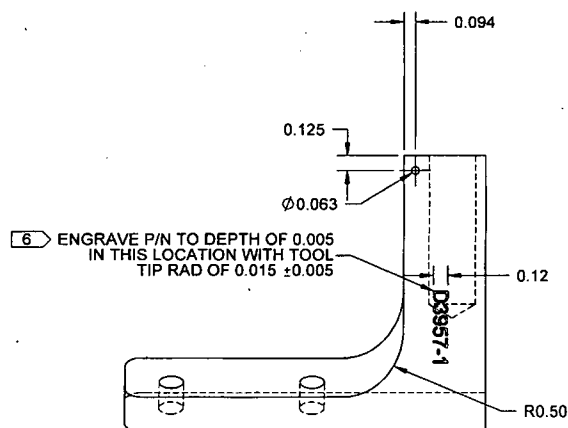
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3957	REV. A
TITLE HINGE	SCALE NTS

COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

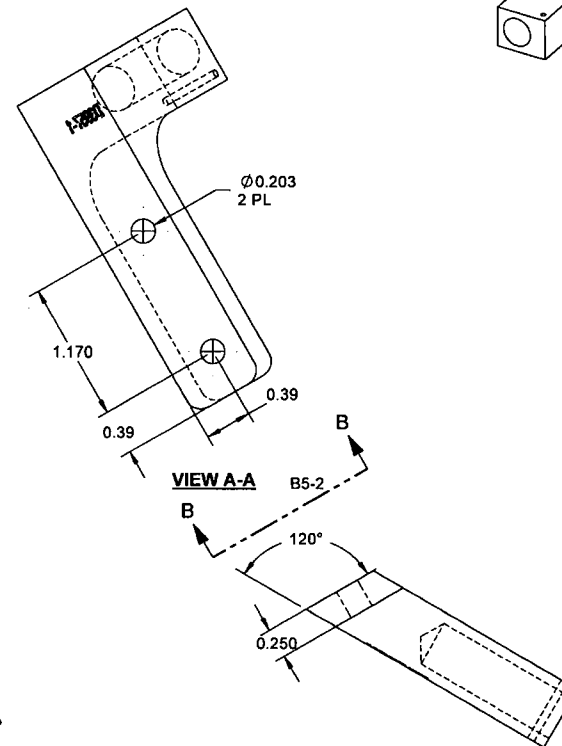
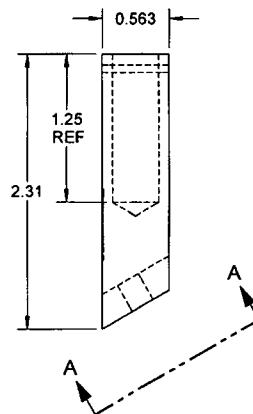
u/o 53957



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\phi 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 ± 0.005









VIEW B-B

D3957-1 HINGE, DOOR LH UPPER

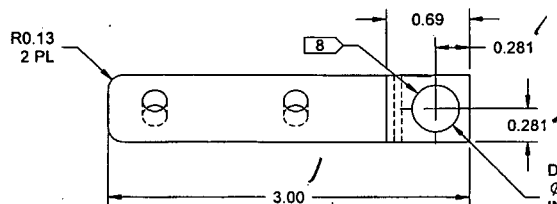
C3-2
RELEASED
 2009-10-08

NOTES:

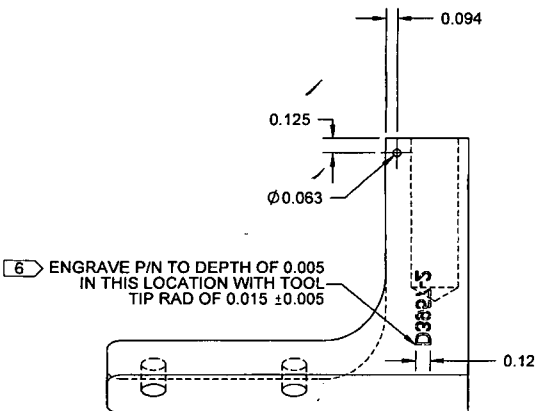
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

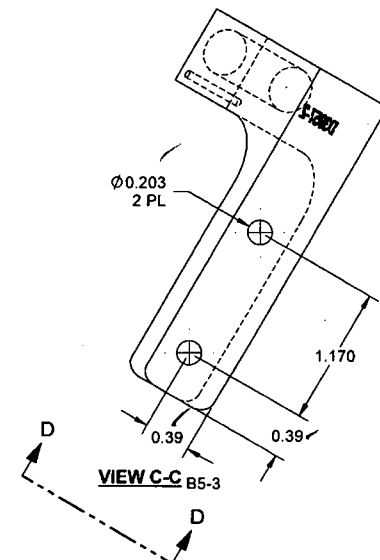
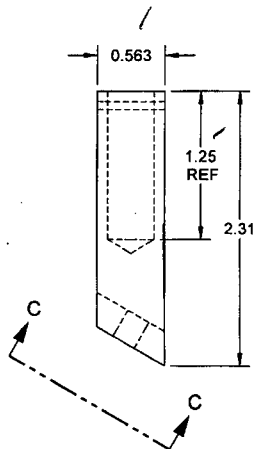
W/0 53957



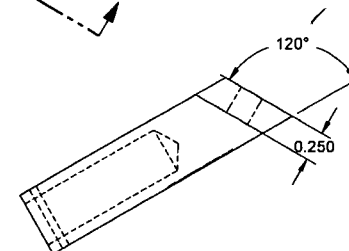
DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\phi 0.391$ X 1.25 DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 ± 0.005



VIEW C-C B5-3



VIEW D-D

C3-3

D3957-2 HINGE, DOOR RH UPPER

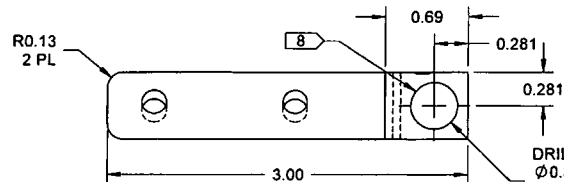
RELEASED
 2009 -10- 08

NOTES:

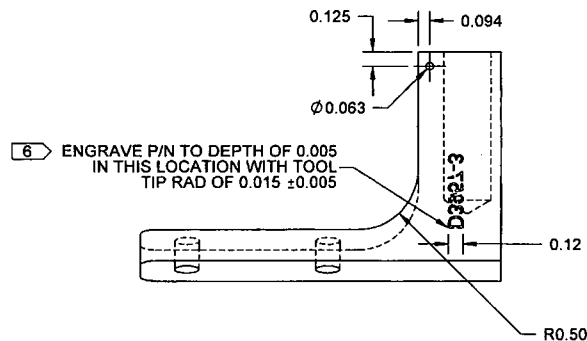
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

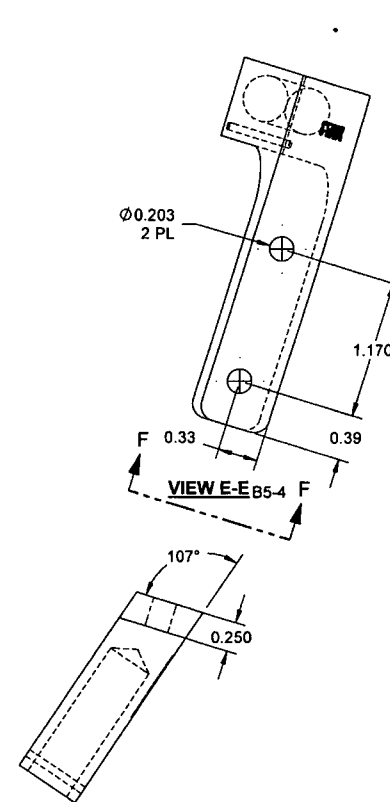
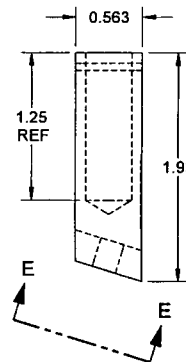
WLO 53957



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005
 IN THIS LOCATION WITH TOOL
 TIP RAD OF 0.015 \pm 0.005



VIEW E-E B5-4 F

VIEW F-F C3-4

D3957-3 HINGE, DOOR LH LOWER

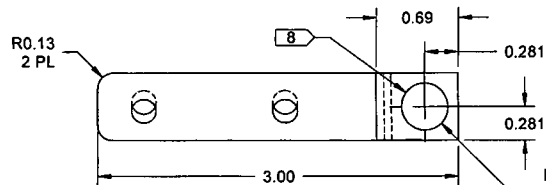
RELEASED
 2009-10-08
map

NOTES:

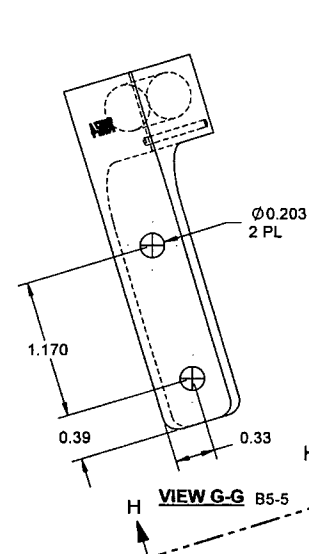
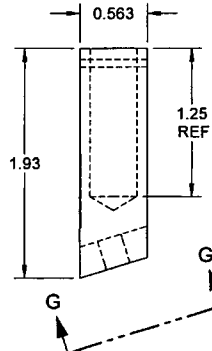
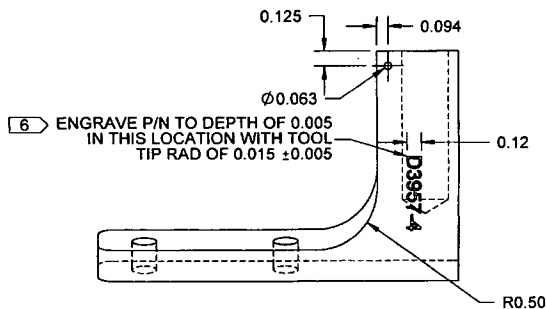
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3957	SHEET 4 OF 5
APPROVED	<i>map</i>	TITLE	SCALE
DE APPR.	<i>map</i>	HINGE	NTS
DATE	09.09.03	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

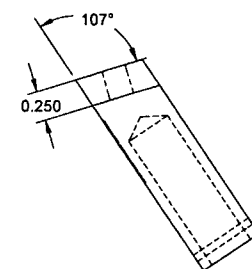
W/O 53952



DRILL AND TAP FOR 3/8-24 HELICAL INSERT
 $\varnothing 0.391 \times 1.25$ DP
 INSTALL HELICOIL MS124818
 FLUSH WITH SURFACE



VIEW H-H C3-5



D3957-4 HINGE, DOOR RH LOWER

NOTES:

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

RELEASED
 2009-10-08
And

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	